

Work Order ID 51153

August 15, 2009 8:46:43 AM



Page 1

Item ID: D3685-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/14/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *YMF*

Date: *09-08-15*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3685

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 09/08/20

4

✓

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685 □2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685□***Ensure holes for AN3C Bolts are free

sealant

SB 09/08/20

4

✓

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) SB 09/08/20

(4)

4

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: B5

0.00

Memo

0.00

08/18/20 (4)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/21 (4)mf 09-08-21

Picklist Print

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Work Order ID: 51153



Parent Item: D3685-041RevC



Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/10/2009

Required Date: 08/14/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A 		Purchased	No			110	Each	547.0000	16.0000			
Bolts												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	547	
106993	7	
110155	2	
110552	3	
110584	45	
111916	20	
112314	470	

MF 09-08-15

D3684-047RevC

Manufactured No



FWD LEG ASS'Y

110 Each 1.0000 4.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
45600	1	

4x B51140. MF
09-08-21

D3684-049RevC

Manufactured No



AFT LEG ASS'Y

110 Each 1.0000 4.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
45601	1	

B 50743

4 SB 09/08/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51153



Parent Item: D3685-041RevC



Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/10/2009

Required Date: 08/14/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3687-3RevB MOUNT		Manufactured	No			110	Each	13.0000	4.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

13

44684

2

45912

2

46761

9

MF 09-08-15 x 2
MF 09-08-15 x 2

D3692-1RevB

Manufactured No

110

Each

107.0000

32.0000



SPACER

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

107

44827

8

45672

14

50325

85

16

Main Warehouse

ST127

161

B50736

32 16

09/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Parent Item: D3685-041RevC



Parent Item Name: BIPOD MOUNT ASSEMBLY



Start Date: 08/10/2009

Required Date: 08/14/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3 		Purchased	No			110	Each	5,488.000	16.0000			
Nut												

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

5408

111819

124

112243

300

112314

4984

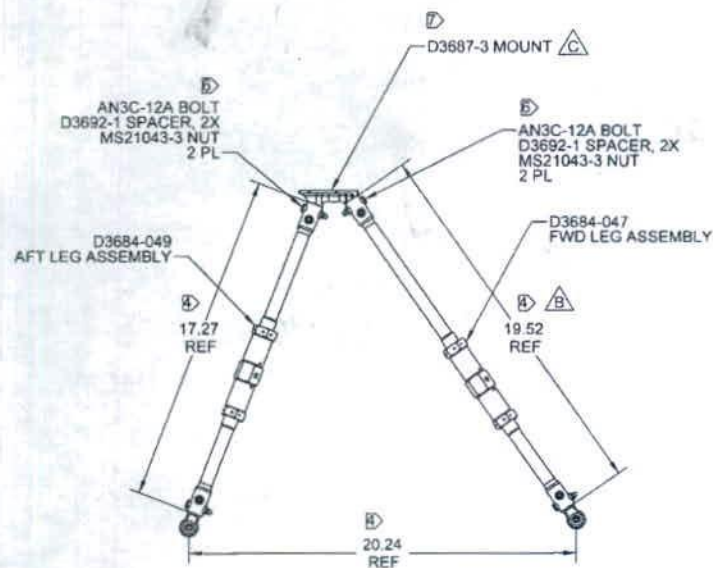
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Shop Packet Print

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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3689-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3685

REV. C
SHEET 1 OF 1

TITLE
BIPOD MOUNT ASSEMBLY

SCALE
NTS

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RELEASED
09/01/2015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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